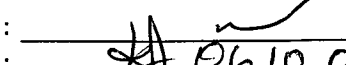
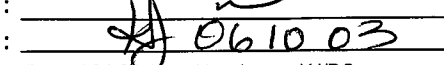


Date: Tuesday, 10/3/2006 2:51:19 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BEARING ASSEMBLY |
| Job Number : 28836 | |
| Estimate Number : 11136 | |
| P.O. Number : N/A | Part Number : D3183045 |
| This Issue : 10/3/2006 S.O. No. : N/A | Drawing Number : D3183 REV.C1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : C1 |
| Previous Run : 28721 | Material : N/A |
| Written By :  | Due Date : 10/20/2006 Qty: 125 Um: Each |
| Checked & Approved By :  061003 | |
| Comment : Est A04.02.18 New issue KJ/DS | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|---------------------|
| 1.0 | MDLRINR1000 | Delrin Round Bar 1" |
|-----|-------------|---------------------|



Comment: Qty.: 0.0350 f(s)/Unit Total : 0.6993 f(s)
 Delrin Round Bar 1"
 Material: Ø1.00 Delrin Rod
 (M-DELRIN-R1.000)
 Identify as D3183-9
 Batch: 101079

4.375

BSG 06.10.07

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL
 Turn D3183-9 Cap as per Folio FA388
 Deburr

BSG 06.10.07

125

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BSG 06.10.07

125

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SD 06.10.08

125

| | | |
|-----|--------|---------|
| 5.0 | D31835 | Bearing |
|-----|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D3183-5 Bearing

3x B28091
 20x B28852
 3x B23979

2ty
24

ml 06/10/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/10/18
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 2:51:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 28836

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

6.0 A



See Bottom

Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

ml 06/10/13

26

7.0

QC5

INSPECT WORK TO CURRENT STEP



06.10.16 26

Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 4/2

~~06.10.10~~

~~06.10.17~~

06/10/17

26

9.0

QC21

FINAL INSPECTION/W/O RELEASE



26

Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

Job Completion



u 06.10.18

6.0 B Make 26 assy D 3183-045

Put Back in stock 90 of D3183-9 Cap ST. 4/2
B 28836

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

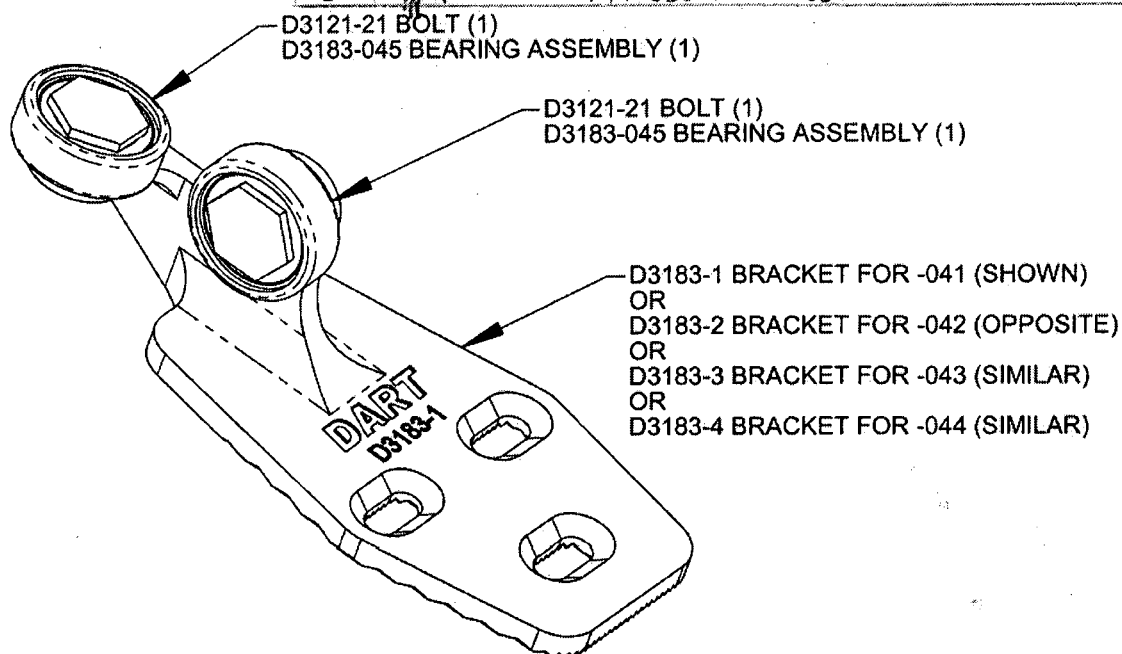
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

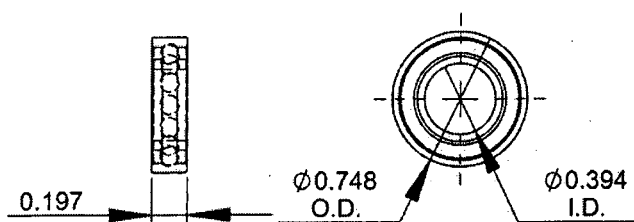


| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY UP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3183 | REV. C SHEET 1 OF 4 |
| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |
| A | 03.01.24 | NEW ISSUE | |
| B | 03.06.17 | REMOVE BEARING; 1.012 WS 0.882 | |
| C | 04.02.17 | ADD -045/-9; 0.182 WAS 0.431 | |
| CI | 04.11.09 | 0.830 WAS 0.850 | |

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

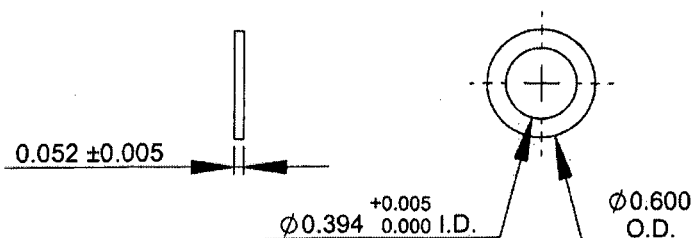


D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
 - 2) POSSIBLE SUPPLIER: NSK P/N 680622
 - 3) ALL DIMENSIONS ARE IN INCHES
- UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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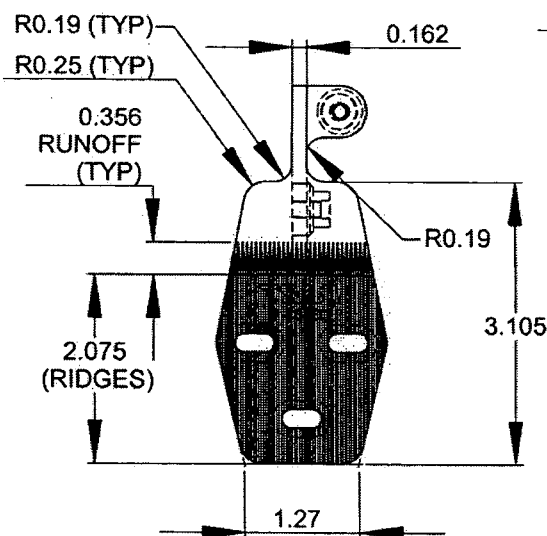
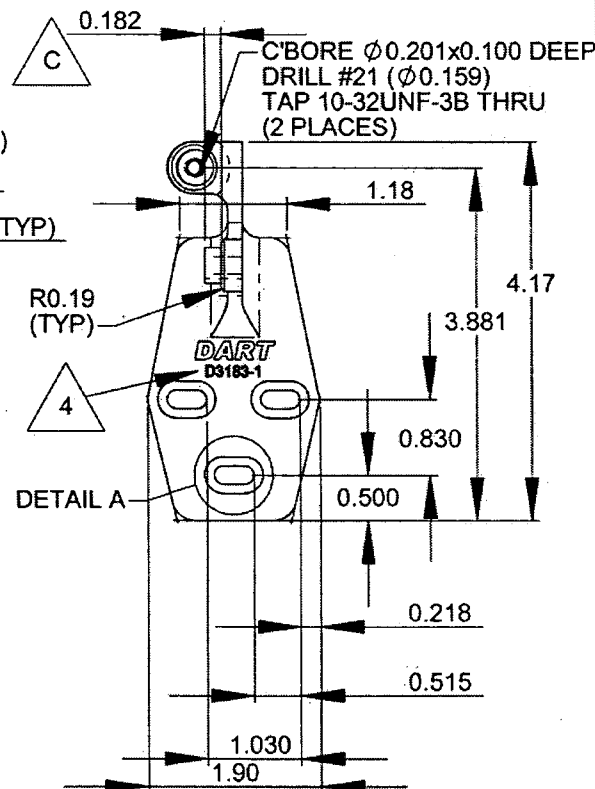
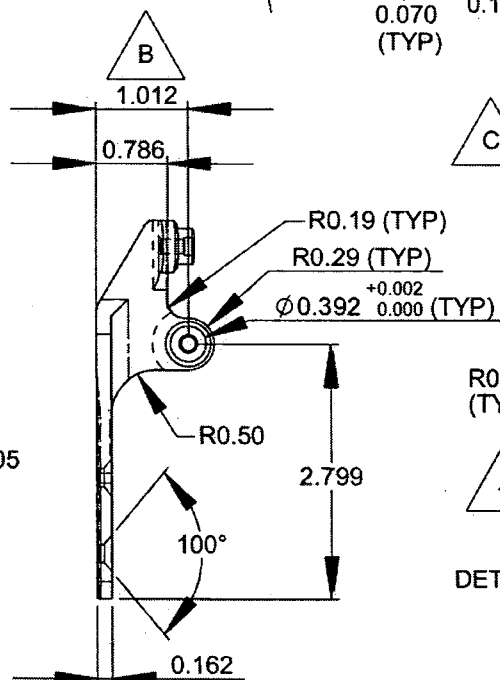
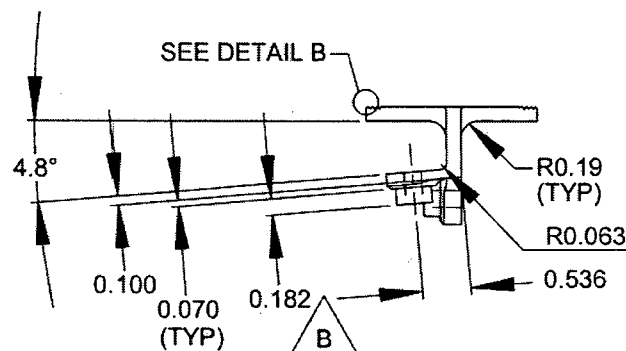
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| DATE | DRAWING NO. | REV. C |
| 04.02.17 | D3183 | SHEET 2 OF 4 |
| | TITLE | SCALE |
| | BRACKET ASSEMBLY | 1:2 |

RELEASED
04.03.01



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

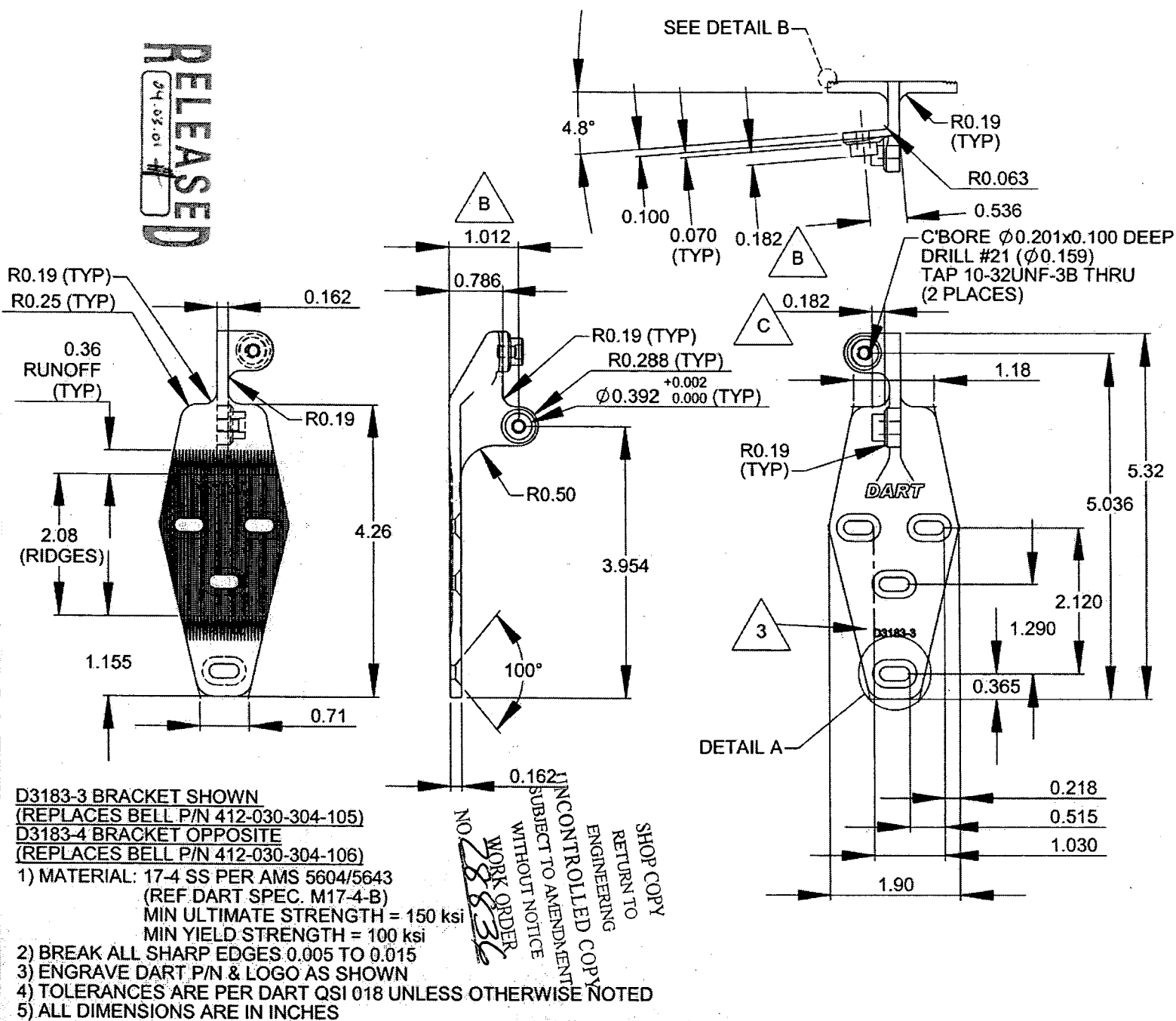
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NO. 288
WORK ORDER

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| CHECKED | APPROVED | DRAWING NO. | REV. C |
| DATE | | D3183 | SHEET 3 OF 4 |
| 04.02.17 | | TITLE | SCALE |
| | | BRACKET ASSEMBLY | 1:2 |

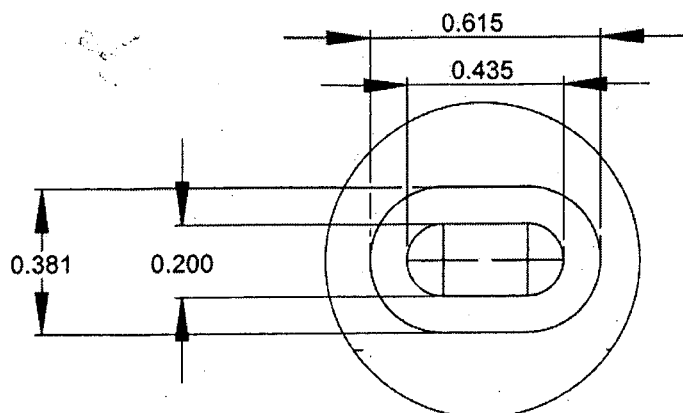


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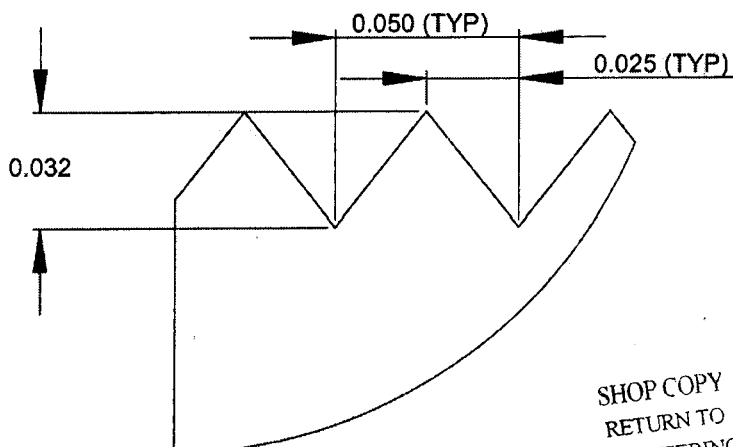


| | | | |
|-------------------------------|----------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3183 | REV. C SHEET 4 OF 4 |
| DATE 04.02.17 | TITLE BRACKET ASSEMBLY | SCALE 1:1 | |



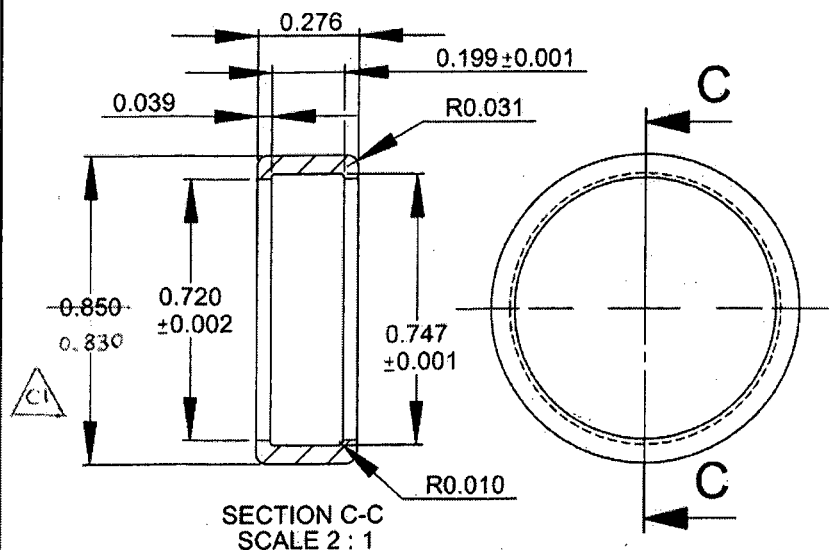
DETAIL A (2 : 1)

RELEASED
04.03.01 *[Signature]*



DETAIL B (20 : 1)

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WORK ORDER
NO. **28836**



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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